Torque Instructions

Husky® 1050 Diaphragm Pumps

406826A

Important Safety Instructions
Read all warnings and instructions in the Husky® 1050 Air-Operated Diaphragm Pump Repair/Parts manual. Save all instructions.

NOTE: Fluid cover and manifold fasteners have a thread-locking adhesive patch applied to the threads. If this patch is excessively worn, the screws may loosen during operation. Replace screws with new ones, or apply medium-strength (blue) Loctite or equivalent to the threads.

If fluid cover or manifold fasteners have been loosened, it is important to torque them using the following procedure to improve sealing.

NOTE: Always completely torque fluid covers before torquing manifolds.

Start all fluid cover screws a few turns. Then turn down each screw just until head contacts cover. Then turn each screw by 1/2 turn or less working in a crisscross pattern to specified torque. Repeat for manifolds.

Fluid cover and manifold fasteners:
100 in-lb (11.3 N•m)

Retorque the air valve fasteners (V) in a crisscross pattern to specified torque.

Air valve fasteners:
55 in-lb (6.2 N•m) for **plastic center sections**
80 in-lb (9.0 N•m) for **metal center sections**

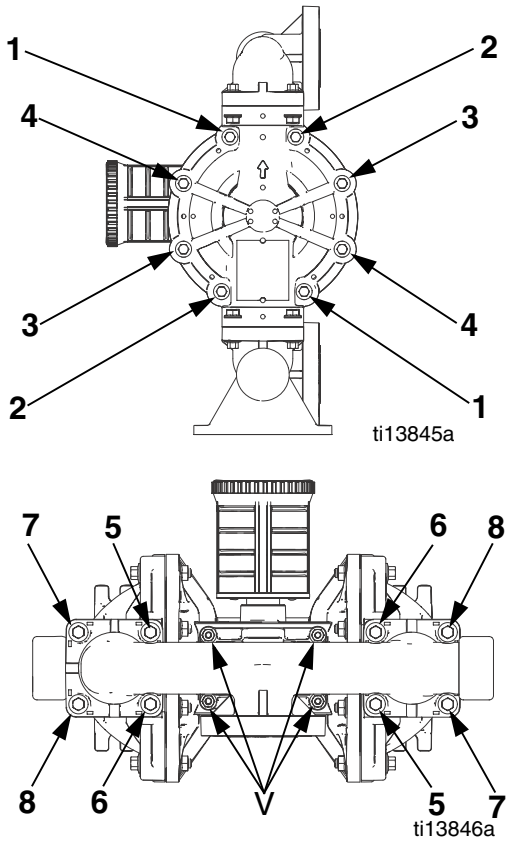

FIG. 1. Torque sequence

Graco Inc. P.O. Box 1441 Minneapolis, MN 55440-1441
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